

ABSTRACT OF THE DISCLOSURE

A casting mold for an engine block and method for manufacturing the casting mold. In one embodiment, the casting mold includes a mold seat with a double-curved surface, and a cast-in cylinder liner. The cylinder liner has an axis and an end surface. The end surface is in tangential contact with the double-curved surface in a seated position prior to any thermal expansion of the cylinder liner. In various embodiments, the cylinder liner becomes slightly unseated upon thermal expansion.